

Ship 27/04

Work Order ID 68595



Monday, April 18, 2011 11:18:55 AM

Item ID: D205-541-048

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, RH

Start Date: 4/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: U

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D205-541

Rev G

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD205-541-048

CHG001

Sub 4/27

for CL 11-4-26

110

0.00



Pick Kit

Memo

0.00

Packaging

Packaging

Per 4/26

120

QC4- 100% Inspect kits for completeness

0.00



Memo

0.00

Quality Control

Sub 4/27

(70)

B68598

**Work Order ID 68595**

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Stop



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Start Date: 4/18/2011 Start Qty: 1.00



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Required Date: 4/27/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD205-541-048								
	Location:								
	PPP Rev:								
140		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

11/4/27

MF

11-04-27

# Picklist Print

Monday, April 18, 2011 11:18:52 AM

Page 1

Work Order ID: 68595

Parent Item: D205-541-048

Parent Item Name: Heli-Access-Step, RH

Start Date: 4/18/2011

Required Date: 4/27/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-02-19 verified by: LL  
 IPP Rev:B Ecn 1157 08-03-19 DD verified by: IPP Rev:C  
 bolt was AN3 now AN4 DD 10.03.18 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-13A Bolt		Purchased	No			110	Each	372.0000	6	6			
<div> <div>Location</div> <div>ST357</div> <div>117313</div> </div> <div> <div>Loc Qty</div> <div>372</div> <div>372</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
AN4-14A Bolt		Purchased	No			110	Each	249.0000	6	6			
<div> <div>Location</div> <div>ST357</div> <div>116914</div> <div>ST358</div> <div>117313</div> </div> <div> <div>Loc Qty</div> <div>49</div> <div>49</div> <div>200</div> <div>200</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													
AN960JD416 Washer	NAS1149D0463J	Purchased	No			110	Each	0.0000	24	24			
D3724-042 Step Assembly		Manufactured	No			110	Each	0.0000	1	1			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, April 18, 2011 11:18:52 AM

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Work Order ID: 68595

Parent Item: D205-541-048

Parent Item Name: Heli-Access-Step, RH

Start Date: 4/18/2011

Required Date: 4/27/2011

Start Qty: 1.00

Required Qty: 1.00

D3731-1

Manufactured No

110

Each

16.0000

1

1



Plate



Location

Loc Qty

Loc Code

ST515

16

38073

1

38434

15

38073  
3

D3751-1

Manufactured No

110

Each

25.0000

2

2



Shim



Location

Loc Qty

Loc Code

ST515

25

38435

25

38435

MS21042L4

Purchased No

110

Each

2,474.000

12

12



Nut



Location

Loc Qty

Loc Code

ST300

2474

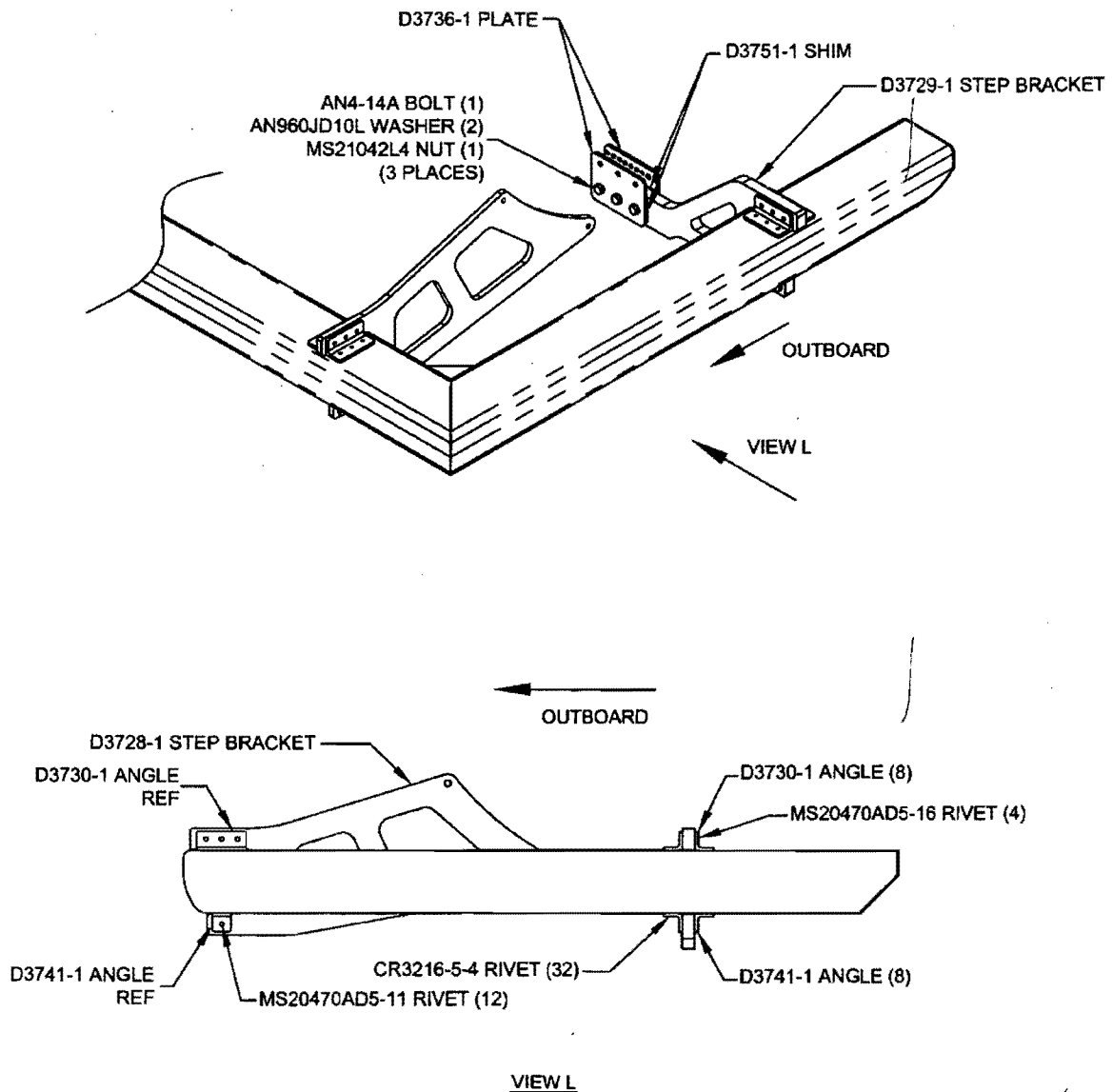
116188

474

116823

2000

116188



**Figure 25-10 – Step Plate Assembly**  
(D205-541-048 Shown; D205-541-047 Opposite)

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**25-00-00**

Revision: 4

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
1*	1*	1*	1*			AN4-22A	BOLT
1*	1*	1*	1*			AN4-24A	BOLT
1	1	1	1			AN5-7A	BOLT
1	1	1	1			AN5-13A	BOLT
4*	4*	4*	4*			AN5-17A	BOLT
				5	5	AN960-10	WASHER (OR NAS1149F0363P) (OPTIONAL)
				20	20	AN960JD10L	WASHER (OR NAS1149D0332J)
2*	2*	6*	6*			AN960JD416	WASHER (OR NAS1149D0463J)
				2	2	AN960-416	WASHER (OR NAS1149F0463P) (OPTIONAL)
27	27	27	27	36	36	AN960JD416	WASHER (OR NAS1149D0463J)
2*	2*	2*	2*	4	4	AN960JD416L	WASHER (OR NAS1149D0416J)
4*	4*	4*	4*			AN960JD516	WASHER (OR NAS1149D0563J)
3	3	3	3			AN960JD516	WASHER (OR NAS1149D0563J)
2	2					AN960JD8	WASHER (OR NAS1149DN832J)
4*	4*	4*	4*			AN970-4	WASHER
2*	2*					MS20600AD4W3	RIVET
2*	2*	2*	2*	8	8	MS21042L3	NUT (OR MS21042-3)
				5	5	MS21042L3	NUT (OR MS21042-3) (OPTIONAL)
4*	4*	5*	5*			MS21042L4	NUT (OR MS21042-4)
16	16	16	16	20	20	MS21042L4	NUT (OR MS21042-4)
				2	2	MS21043L4	NUT (OR MS21043-4)
4*	4*	4*	4*			MS21042L5	NUT (OR MS21042-5)
2	2	2	2			MS21042L5	NUT (OR MS21042-5)

\* = ASSEMBLED AT DART

## 6.0 PARTS LIST HELI-ACCESS-STEP™

Qty -047	Qty -048	Part Number	Description
X		D205-541-047	HELI-ACCESS-STEP, LH
	X	D205-541-048	HELI-ACCESS-STEP, RH
1		D3724-041	STEP ASSY, LH
	1	D3724-042	STEP ASSY, RH
2	2	D3731-1	PLATE
2	2	D3751-1	SHIM
6	6	AN4-13A	BOLT
6	6	AN4-14A	BOLT
24	24	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)